

Work Order ID 63121

Thursday, October 21, 2010 1:29:29 PM

Page 1

Item ID: D2563

Accept

Revision ID:

Item Name: Step Weldment Assembly

Start Date: 10/21/2010 Start Qty: 2.00

Required Date: 10/28/2010 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date: 10/10/21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2563

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Deburr ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



10.10.28

2 of

2 of 2 10/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/10/29

(X2)

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

=> H 10/10/29

(X2)

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

H 10.11.02

2

W/O:		WORK ORDER CHANGES					
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Thursday, October 21, 2010 1:29:29 PM



Page 3

Item ID: D2563

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 10/21/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: M108436 0.00
Large Fab

Memo

0.00

10.11.022φ

1-Inspect for foreign object per QSI 024

2-Weld Remaining End cap as per Dwg D2563 using DT 8343

3-Grind

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

2φBE10/11/02

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

10.11.022

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, October 21, 2010 1:29:29 PM



Page 4

Item ID:	D2563	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Weldment Assembly					
Start Date:	10/21/2010	Start Qty:	2.00			
Required Date:	10/28/2010	Req'd Qty:	2.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
175 	Pressure Wash per QSI005 4.3	0.00							
HandFinish	Memo	0.00				2		BR 10-11-2	
Hand Finishing	Touch up Alodine as per QSI005								
180 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00				2		BR 10-11-3	
Powder Coating	Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3								
	START TIME: 8:00 OVEN TEMPERATURE: 320° FINISH TIME: 8:30								
190 	Wing Walk as per dwg QSI005 4.4 Batch M115760	0.00							
HandFinish	Memo	0.00				2		q	
Hand Finishing									

10/11/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, October 21, 2010 1:29:29 PM



Page 5

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Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

②

210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PAP 63150

0.00

Packaging

②

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/18

MF

10-11-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, October 21, 2010 1:29:33 PM

Page 1

Work Order ID: 63121

Parent Item: D2563

Parent Item Name: Step Weldment Assembly





Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116  Step Extrusion		Manufactured	No			100	Each	112.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				112					
				57850				31					
				60307				81					
D2561  Lug		Manufactured	No			100	Each	23.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				23					
				60096				23					
D2564  Mounting Angle		Manufactured	No			100	Each	13.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				13					
				60097				13					
D2673-34  End Plate		Manufactured	No			100	Each	160.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				160					
				57527				1					
				59690				159					

10.10.27

10.10.27

10.10.27

10.10.27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 63121



Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

D2673-34

Manufactured No

150

Each

160.0000

1

2



10.11.02

End Plate

Location

Loc Qty

Loc Code

WA

160

57527

1

59690

159

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

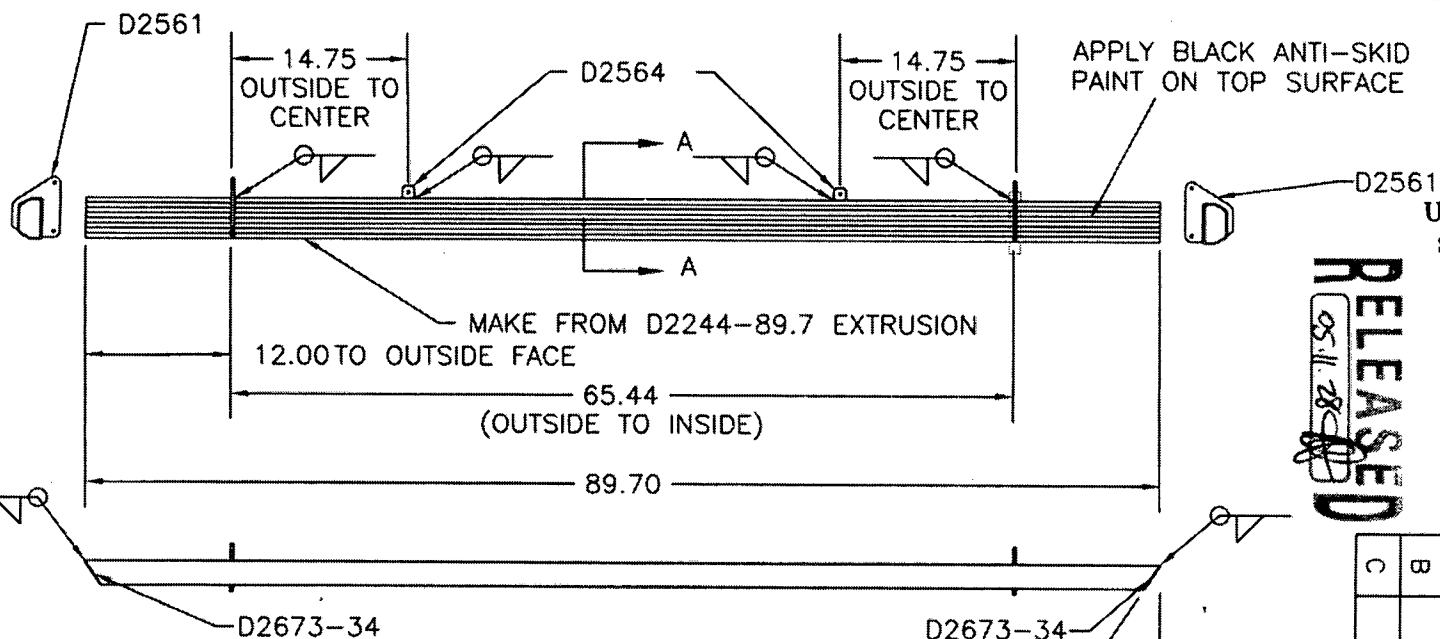
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.28

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	Ht	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
Ht	Ht	D2563
DATE	TITLE	REV. C
05.11.14	STEP WELDMENT ASSEMBLY	1:15
A	96.04.26	NEW ISSUE
B	97.05.14	END CAPS CHANGED (WAS D2248)
C	05.11.14	UPDATE NOTES

SHOP COPY
RETURN
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK OF
NO. 63

210-10.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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